

5133664



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6101-015
Job Sheet 185841



Part No: D6101-015

Job Qty: 20 ea

Part Name: Saddle Billet



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/18

Job Tracking No:

Due Date: 11/26/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	20 pcs		11/26/18	0.00	0.00	Purchasing		AT 18/11/30
110	Packaging	20 pcs		11/26/18	0.00	0.00	Packaging2		AT 18/11/30 DAS
120	QC	20 pcs		11/26/18	0.00	0.00	QC18		61
130	Packaging	20 pcs		11/26/18	0.00	0.00	Packaging3-2		9-89
140	QC21-SA	20 Ea		11/26/18	0.00	0.00	QC21		21 DEC 03 2018

Part Op 100 - Issue P/O: 41594 b) 9.450" x 6.250" x 2.50" thick (+0.030 / -0.000) d) Grain direction along 9.450"

Descriptions: length

110 - Ensure material certification is attached

120 - Ensure Material certification comply to Dwg D6101

130 - LOCATION: MAT045

NOV 05 2018

x20

DAS
13
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-015P	Aluminum Billet	20 pcs (1 ea)	100-Purchasing	5133662

Job Allocations

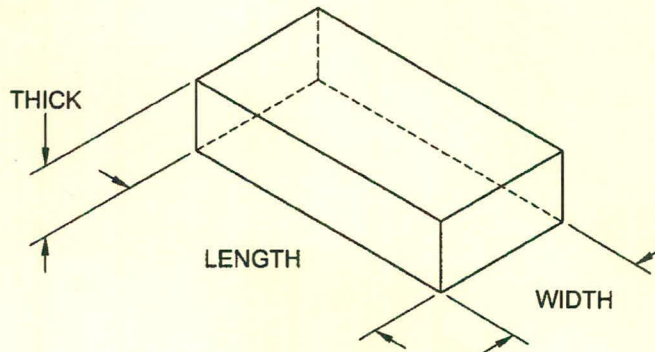
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6101-015P	20	0	0

Part Specifications

Specifications could not be found.

Plex 11/5/18 7:19 AM dart.lavoie.chantal

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/WB

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	 	DRAWING NO. REV. B	
MFG. APPR.		D6101 SHEET 1 OF 1	
APPROVED		TITLE SCALE	
DE APPR.		SADDLE BILLET, 7075 NTS	
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041594**

Supplier: MEC002-VU
Metaux Castle
P.O. Box 4090 Stn A
Toronto
ON
M5W OE9 Canada

PO No: PO041594

PO Date: 11/5/18

Due Date: 11/26/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
NOV 06 2018

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	185840	D6101-001P		7075-T7351 2X6X6.25 : Various STC's AS PER DWG D6101 REV. B SIZE: 6.00" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 6.00" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	11/26/18	20 pcs	0 pcs	20 pcs	\$29.57/pcs	\$591.40
2	185839	D6101-003P		7075-T7351 2X6.25X7.875 : Various STC's AS PER DWG D6101 REV. B SIZE: 7.875" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 7.875" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	11/26/18	20 pcs	0 pcs	20 pcs	\$38.82/pcs	\$776.40



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PURCHASE ORDER PO041594

Items												
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
3	185838	D6101-005P		7075-T7351 8.25X5.0X2.5 : Various STC's AS PER DWG.D6101 REV.B SIZE: 5.00" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG 5.00" LENGHT MATERIAL: 7075- T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	11/26/18	20 pcs	0 pcs	20 pcs	\$40.54/pcs	\$810.80
4	185837	D6101-007P		7075-T7351 8.25X7.75X2.5 : Various STC's AS PER DWG D6101 REV. B MATERIAL: 7075- T7351 (QQ-A- 250/12) SIZE: 7.750" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG: 7.750" LENGTH TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	11/26/18	40 pcs	0 pcs	40 pcs	\$61.72/pcs	\$2,468.80
5	185841	D6101-015P		Aluminum Billet : Various STC's As per Dwg D6101 Rev. B	Firmed	-	11/26/18	20 pcs	0 pcs	20 pcs	\$57.20/pcs	\$1,144.00
6	185842	D6101-017P		Aluminum Billet : Various STC's As per Dwg D6101 Rev. B	Firmed	-	11/26/18	12 pcs	0 pcs	12 pcs	\$32.64/pcs	\$391.68
7	185843	D6103-003P		Round Alum Billet : Various STC's AS PER DWG D6103 REV. B MATERIAL: 7075- T7351 AS PER QQ- A-225/9 SIZE: 3.500" X 12.500" LONG	Firmed	-	11/26/18	20 pcs	0 pcs	20 pcs	\$60.40/pcs	\$1,208.00



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PURCHASE ORDER **PO041594**

Items												
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
8 <i>AT</i>	185844	D6104-005P		17-4 SS Roundbar 4.00"Od : Various STC's AS PER DWG D6104 REV. B MATERIAL: 17-4 PH AS PER AMS 4643 OR AISI 630 SIZE: 4.00" X 5.10" LONG	Firmed	-	11/26/18	20 pcs <i>✓ 20x</i>	0 pcs <i>AT 18/11/12</i>	20 pcs	\$54.20/pcs	\$1,084.00
Grand Total:												\$8,475.08

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/5/18 1:16 PM dart.lavoie.chantal

**INTERORG TRANSFER
PACKING SLIP/
CERTIFICATE OF CONFORMANCE**

Page 1 of 2

Shipment No:3758047

Ship From: A. M. CASTLE & CO. 14001 ORANGE AVENUE PARAMOUNT, CA 90723 USA		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped	F.O.B.	Freight Terms		Carrier		BOL No	
15-NOV-18	ORIGIN	Prepaid		ARCBEST		3758047-2	

Shipment Details	Final Destination Branch - TOR
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Order No	Line No	Item No	Description	
5310861	3	752241.MO	2.5000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT RECTANGLE TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 9.45")) X 9.45 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 9.45")) - ALUMINUM PLATE SAW/SPECIFICATIONS: AMS-QQ-A-250/12	
Purchase Order No		Part Number	Ordered Qty	Invoice Qty
41594		YOUR ITEM NUMBER: D6101-015	20.00 PCS	20.00 PCS

Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
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Delivery No.	Mill/Source	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
122411091	KAISER ALUMINUM			20			305.4241

These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. Government or as otherwise authorized by U.S. law and regulations.

Date Printed: 15-NOV-2018 04:39:34 PM

INTERORG TRANSFER
PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

Name:



SHIP TO:

A M CASTLE & CO
14001 ORANGE AVE
P.O. BOX 1402
PARAMOUNT, CA 90723

KAISER ALUMINUM

Trentwood Works

PO Box 15108, Spokane Valley WA 99215-5108

15000 E Euclid, Spokane Valley WA 99216

Phone: (800) 367-2586

SOLD TO:

AM CASTLE & CO- SOLD TO
1420 KENSINGTON RD
SUITE 220
OAK BROOK, IL 60523

CERTIFIED TEST REPORT

Serial Number

4534396

CUSTOMER PO NUMBER: 475164-1	WORK PACKAGE:	CUSTOMER PART NUMBER: 752241	SHIP RUN/LOAD: 104436/12	GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1266431-1	SHIP DATE: 29-OCT-2018	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: KaiserSelect Plate
WEIGHT SHIPPED: 7162 LB (3248.66 KG)	QUANTITY: 4 PCS EST.	TRUCK B/L #: 2076952	GUAGE: 2.5000 IN (63.5000 MM)	DIAMETER/WIDTH: 48.500 IN (1231.9 MM)	LENGTH: 144.500 IN (3670.3 MM)

MHU 2276716: LOT 280418B5: 2 pieces;

MHU 2276717: LOT 280418B5: 2 pieces;

Certified Specifications

AMS 4078/RevK
ASTM B 209/Rev14
BSS 7055/RevB
DPS 4.713/RevAK
GSS16100/RevG/Amd1
PS 21211/RevP

AMS-QQ-A-250/12/RevA
ASTM B 594/Rev13
CMMP 025/RevV
EAC MS1011/RevE
MMS 159/RevT

AMS-STD-2154/RevC
BAC 5439/RevJ
CSTI 006/RevE
GAMPS 9101/RevB/AmdSCN1
PPS 20.04/Rev7

Test Code: 4297

Lot: 280418B5

Cast 713

Drop 06

Test Results

Ingot 1

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	68.3 : 68.8 (471 : 474)	57.3 : 57.7 (395 : 398)	10.9 : 12.0

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	41.4 Min	42.5 Max
(MS/M) :	24.0 Min	24.7 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.07	0.19	1.4	0.02	2.4	0.20	5.5	0.03	0.01	0.01	TOT 0.03



KAISER ALUMINUM

Trentwood Works
PO Box 15108, Spokane Valley WA 99215-5108
15000 E Euclid, Spokane Valley WA 99216
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4534396

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075												
MIN(wt%)	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

ORDER COMMENTS

AMC CA-15413B R 9

TEST NOTES

Metal represented by this test report was 100% Type I
(immersion) ultrasonically tested from one side with 3mm
dead zones top and bottom and meets the Class A and Class B
requirements of all specifications referenced on this test
report. No surface marking of sonic indications is
performed.

CERTIFICATION

Kaiser Aluminum, Trentwood Works, is ISO 9001, AS9100, and ISO 14001 certified, and hereby certifies that all material shipped under this order:

- * has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein.
- All test equipment and measuring devices are calibrated and certified in accordance applicable specifications. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements. Reported elongation values have been measured as elongation at fracture.
- * was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
- * has been thermally processed in compliance with AMS 2772, where applicable.
- * is mercury free, within the limits of detection of ASTM E1215 (< 1ppm).
- * is in compliance with RoHS 2, European Union Directive 2011/65/EU.
- * is in compliance with European Chemical Agency, ECHA, REACH regulations, (EC) No 1907/2006, and Kaiser regularly monitors these regulations for updates.
- * is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.
- * is free of weld repair.
- * meets the reporting requirements of EN10204, Type 3.1.

Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.



Michael Peske, PT Lab Process Engineer

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: DG101-015

DATE: 18/11/30

PO / BATCH NO.: P0041594/S133664

MATERIAL CERT REC'D: Yes

QUANTITY RECEIVED: 20x

QUANTITY INSPECTED: 20x

QUANTITY REJECTED: 0

THICKNESS ORDERED: 2.500"

THICKNESS RECEIVED: 2.500"

SHEET SIZE ORDERED:

SHEET SIZE RECEIVED:

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	Y (N)	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	Y (N)	
CORRECT MATERIAL PER M-DRAWING	Y (N)	AMS QQ-A-250/12
CORRECT THICKNESS	Y (N)	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	Y (N)	MT: 280418B5
CORRECT MATERIAL IDENTIFICATION	Y (N)	
CORRECT M# ON THE MATERIAL	Y (N)	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK.					
RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	WEBSTER

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY:	<u>61</u> <u>9-89</u>	SIGNED OFF BY:	_____
DATE:	<u>18/11/30</u>	DATE:	_____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

